

Work Order ID 69419

Tuesday, May 10, 2011 3:31:35 PM



Page 1

Item ID: D3436-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Step RH

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr.

Revision Nbr

D3436

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436 Dwg Rev: A

Qty ☐ Part Number ☐ Description ☐

Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐ M19317

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev:

A Qty ☐ Part Number ☐ Description ☐

Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐ M19317

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty ☐ Part Number ☐ Description ☐

Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐ M19317

11-09-06 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

0.00

1-Slit part D3436-041 on bandsaw as per Dwg D3436
2- deburr

11.09.06

2

0

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

2

0

BEN/09/06

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8.10.06

2

R17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 69419

Tuesday, May 10, 2011 3:31:35 PM



Page 3

Item ID: D3436-044

Accept



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Revision ID:

Stop



Item Name: Step RH

Start Date: 5/10/2011 Start Qty: 2:00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Apply black anti-rust paint as per Dwg D3436 and QSI 005 4.4

wingwalk: M118313

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

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0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

2x ✓ M-11/09/06
RH

150

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

2x RH d M 11/09/06

155

0.00



Small Fab

Small Fab

Memo

0.00

Bond pads per dwg and QSI 015

JS 11/09/07 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69419

Tuesday, May 10, 2011 3:31:35 PM



Page 4

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Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 160 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 86107/07 | | (+2) RM | | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: _____ Memo | 0.00 0.00 | | | | | 11/9/17 | SL (2) | |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 11/9/17 | MR |

11-09-07

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 3:31:46 PM

Page 1

Work Order ID: 69419

Parent Item: D3436-044

Parent Item Name: Step RH



Start Date: 5/10/2011

Required Date: 5/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.05.11 New Issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3436-5

Manufactured

No

100

Each

28.0000

4

8



Bushing

Location

Loc Qty

Loc Code

ST

20

46592

20

WA020

8

64065

8

D3436-7

Manufactured

No

100

Each

46.0000

1

2



Cap

Location

Loc Qty

Loc Code

WA021

46

56836

46

D3436-9

Manufactured

No

100

Each

6.0000

2

4



Pad

Location

Loc Qty

Loc Code

GA

2

56830

2

ST053

4

66567

4

11.09.02

4+4

11.09.02

2

5/10/07

869599

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 3:31:46 PM

Page 2

Work Order ID: 69419

Parent Item: D3436-044

Parent Item Name: Step RH

Start Date: 5/10/2011

Required Date: 5/30/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-4

Manufactured No

100 Each

2.0000

1

2



Right Step



5/11.09.02

Location

Loc Qty

Loc Code

WA021

2

51786

2

2

D3436-1

Manufactured No

155 Each

44.0000

1

2



Clamp



5/11.09.02

Location

Loc Qty

Loc Code

WA021

44

17679

44

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|-------------------------|----------------------------------|--|------------------------|
| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3436 | REV. A SHEET 1 OF 4 |
| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SCALE 1:4 |
| A | 05.04.28 | NEW ISSUE | |

SHOP COPY

RETURN TO
ENGINEERING

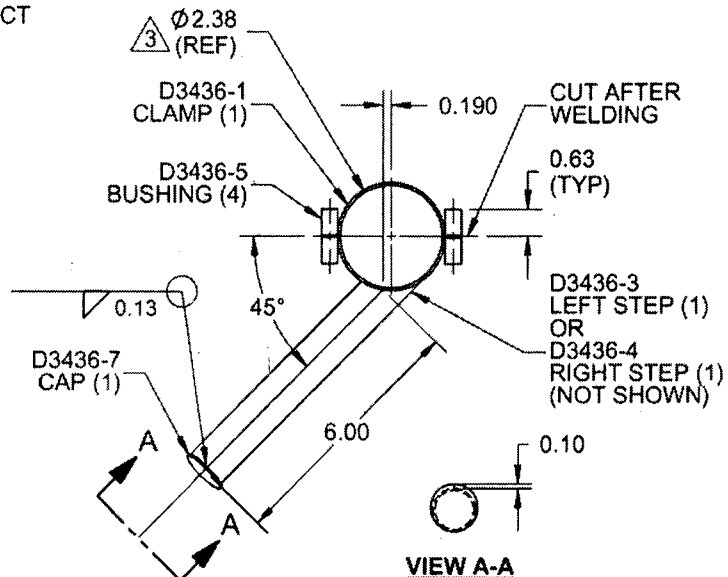
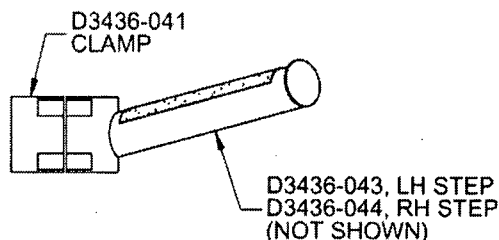
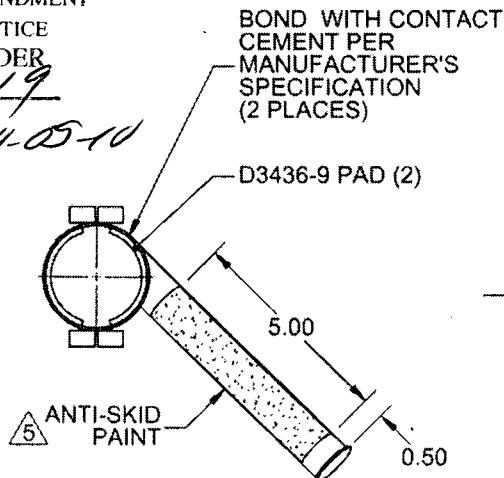
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SUBJECT TO AMENDMENT

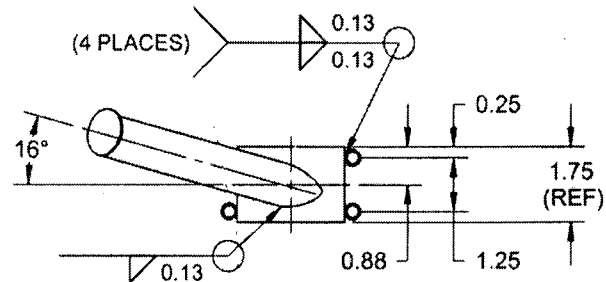
WITHOUT NOTICE
WORK ORDER

NO. 094119

11-05-10



VIEW A-A



WELDING

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05-05-27

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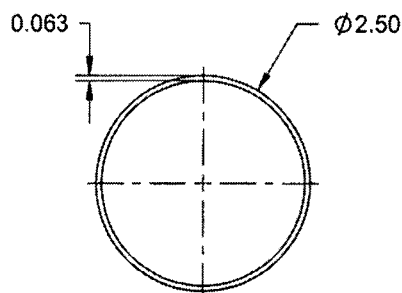
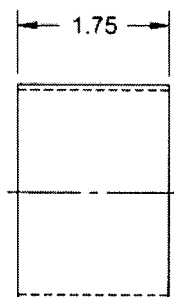
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NOTE: Date & initial all entries



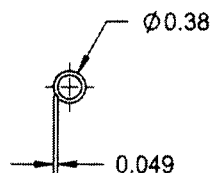
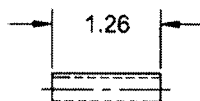
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| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3436 | REV. A SHEET 2 OF 4 |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SCALE 1:2 |



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)

u/b Gary



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

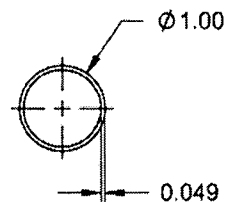
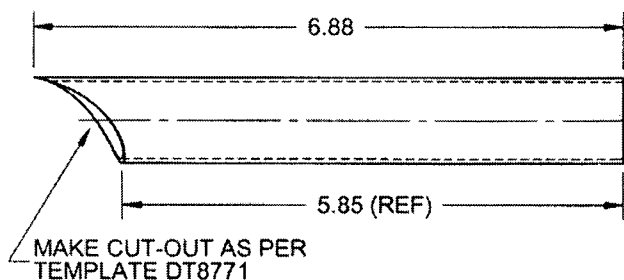
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NOTE: Date & initial all entries



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| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3436 | REV. A SHEET 3 OF 4 |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SCALE 1:2 |

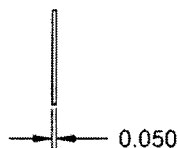
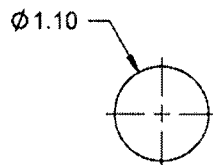
u/v 69419



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

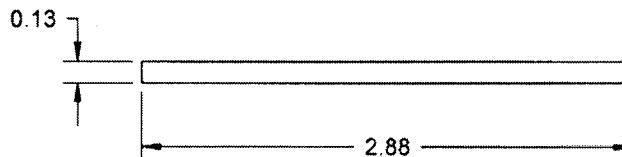
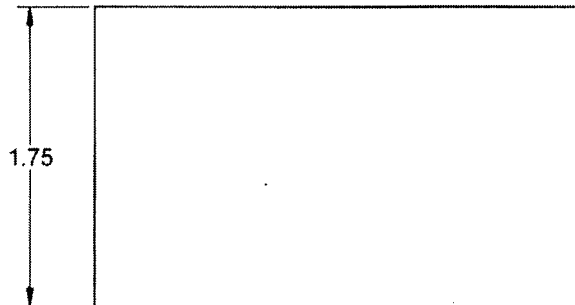
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NOTE: Date & initial all entries



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| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3436 | REV. A SHEET 4 OF 4 |
| DATE 05.04.28 | | TITLE MAINTENANCE STEP | SCALE 1:1 |

u to 09419



RELEASED
05-05-27 H

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries